

Date: Thursday, 4/26/2007 3:33:46 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COLLECTIVE CONTROL STICK
Job Number : 32073	
Estimate Number : 12833	
P.O. Number : <i>N/A</i>	Part Number : G10201
This Issue : 4/26/2007 S.O. No. : <i>NA</i>	Drawing Number : G10201 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 31945	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/18/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 2 Um: Each
Comment : Est Rev. A New Issue 07-04-16 JLM	<i>W24 yth</i>

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR1125W065	304 RD Tube 1.125 x .065w
-----	----------------	---------------------------



Comment: Qty.: 2.6250 f(s)/Unit Total: 5.2500 f(s)
 304 RD Tube 1.125 x .065w
 Batch: *M104134*

MS 07/05/03

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Cut as per Dwg G10202.

MS 07/05/03

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/03

4.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



Comment: CONVENTIONAL LATHE
 Turn as per Dwg G10201

MS 07/05/03

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SB 07-05-03

6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
 Weld assembly as per dwg G10202
 A/R SS Rod Batch: *M102756*

MS 07/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AP Date: 07/05/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/26/2007 3:33:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE CONTROL STICK

Job Number: 32073

Part Number: G10201

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 07-05-07 (2)

8.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Drill as per Dwg.

→ done by Eric Dunning 01/11/10 07/05/10 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SF 244

7/5/10 SQ (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/27/10

Job Completion



W 8/10/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

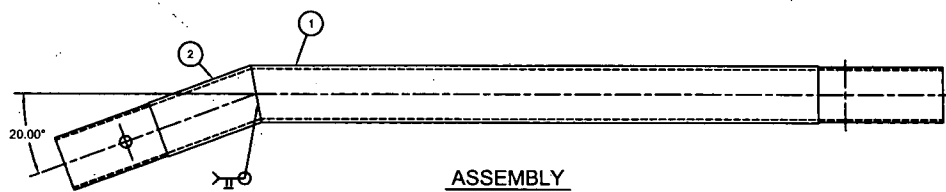
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

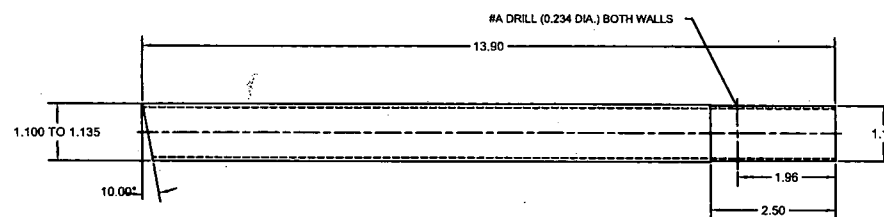
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

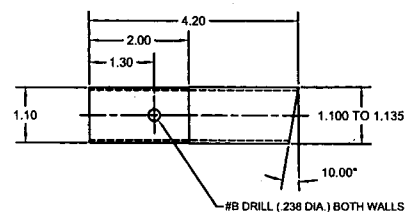
REVISIONS		
REV	DESCRIPTION	APPROVED
A	REDRAWN ON CAD	5/30/03 CLB



ASSEMBLY



ITEM -1



ITEM -2

NOTES: DEBURR ALL SHARP EDGES.
OPTIONAL: TEXT MAY BE ENGRAVED,
STAMPED OR PRINTED ON PART AS DESIRED

1	-2	1.100 -1.135 O.D. X .058 -.070 WALL	304 STAINLESS TUBING
1	-1	1.100 -1.135 O.D. X .058 -.070 WALL	304 STAINLESS TUBING
QTY	DASH	DESCRIPTION	MATERIAL
BREAK SHARP EDGES	125	DESIGNED	DATE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CLB	5/30/03
TOLERANCES ARE:		DRAWN	DATE
FRACTIONS DECIMAL ANGLES		CHECKED	DATE
1/16" 1/32" 1/64" 1/8" 1/4" 1/2" 3/4" 1" 2" 3" 4" 6" 8" 12" 18" 24" 36" 48" 60" 72" 96" 120" 144" 180" 216" 240" 288" 360" 432" 480" 576" 720" 864" 1008" 1152" 1296" 1440" 1728" 2160" 2592" 3024" 3628" 4320" 5184" 6144" 7296" 8712" 10368" 12441" 15168" 18192" 21600" 25920" 30240" 36288" 43200" 51840" 61440" 72960" 87120" 103680" 124416" 151680" 181920" 216000" 259200" 302400" 362880" 432000" 518400" 614400" 729600" 871200" 1036800" 1244160" 1516800" 1819200" 2160000" 2592000" 3024000" 3628800" 4320000" 5184000" 6144000" 7296000" 8712000" 10368000" 12441600" 15168000" 18192000" 21600000" 25920000" 30240000" 36288000" 43200000" 51840000" 61440000" 72960000" 87120000" 103680000" 124416000" 151680000" 181920000" 216000000" 259200000" 302400000" 362880000" 432000000" 518400000" 614400000" 729600000" 871200000" 1036800000" 1244160000" 1516800000" 1819200000" 2160000000" 2592000000" 3024000000" 3628800000" 4320000000" 5184000000" 6144000000" 7296000000" 8712000000" 10368000000" 12441600000" 15168000000" 18192000000" 21600000000" 25920000000" 30240000000" 36288000000" 43200000000" 51840000000" 61440000000" 72960000000" 87120000000" 103680000000" 124416000000" 151680000000" 181920000000" 216000000000" 259200000000" 302400000000" 362880000000" 432000000000" 518400000000" 614400000000" 729600000000" 871200000000" 1036800000000" 1244160000000" 1516800000000" 1819200000000" 2160000000000" 2592000000000" 3024000000000" 3628800000000" 4320000000000" 5184000000000" 6144000000000" 7296000000000" 8712000000000" 10368000000000" 12441600000000" 15168000000000" 18192000000000" 21600000000000" 25920000000000" 30240000000000" 36288000000000" 43200000000000" 51840000000000" 61440000000000" 72960000000000" 87120000000000" 103680000000000" 124416000000000" 151680000000000" 181920000000000" 216000000000000" 259200000000000" 302400000000000" 362880000000000" 432000000000000" 518400000000000" 614400000000000" 729600000000000" 871200000000000" 1036800000000000" 1244160000000000" 1516800000000000" 1819200000000000" 2160000000000000" 2592000000000000" 3024000000000000" 3628800000000000" 4320000000000000" 5184000000000000" 6144000000000000" 7296000000000000" 8712000000000000" 10368000000000000" 12441600000000000" 15168000000000000" 18192000000000000" 21600000000000000" 25920000000000000" 30240000000000000" 36288000000000000" 43200000000000000" 51840000000000000" 61440000000000000" 72960000000000000" 87120000000000000" 103680000000000000" 124416000000000000" 151680000000000000" 181920000000000000" 216000000000000000" 259200000000000000" 302400000000000000" 362880000000000000" 432000000000000000" 518400000000000000" 614400000000000000" 729600000000000000" 871200000000000000" 1036800000000000000" 1244160000000000000" 1516800000000000000" 1819200000000000000" 2160000000000000000" 2592000000000000000" 3024000000000000000" 3628800000000000000" 4320000000000000000" 5184000000000000000" 6144000000000000000" 7296000000000000000" 8712000000000000000" 10368000000000000000" 12441600000000000000" 15168000000000000000" 18192000000000000000" 21600000000000000000" 25920000000000000000" 30240000000000000000" 36288000000000000000" 43200000000000000000" 51840000000000000000" 61440000000000000000" 72960000000000000000" 87120000000000000000" 103680000000000000000" 124416000000000000000" 151680000000000000000" 181920000000000000000" 216000000000000000000" 259200000000000000000" 302400000000000000000" 362880000000000000000" 432000000000000000000" 518400000000000000000" 614400000000000000000" 729600000000000000000" 871200000000000000000" 1036800000000000000000" 1244160000000000000000" 1516800000000000000000" 1819200000000000000000" 2160000000000000000000" 2592000000000000000000" 3024000000000000000000" 3628800000000000000000" 4320000000000000000000" 5184000000000000000000" 6144000000000000000000" 7296000000000000000000" 8712000000000000000000" 10368000000000000000000" 12441600000000000000000" 15168000000000000000000" 18192000000000000000000" 21600000000000000000000" 25920000000000000000000" 30240000000000000000000" 36288000000000000000000" 43200000000000000000000" 51840000000000000000000" 61440000000000000000000" 72960000000000000000000" 87120000000000000000000" 103680000000000000000000" 124416000000000000000000" 151680000000000000000000" 181920000000000000000000" 216000000000000000000000" 259200000000000000000000" 302400000000000000000000" 362880000000000000000000" 432000000000000000000000" 518400000000000000000000" 614400000000000000000000" 729600000000000000000000" 871200000000000000000000" 1036800000000000000000000" 1244160000000000000000000" 1516800000000000000000000" 1819200000000000000000000" 2160000000000000000000000" 2592000000000000000000000" 3024000000000000000000000" 3628800000000000000000000" 4320000000000000000000000" 5184000000000000000000000" 6144000000000000000000000" 7296000000000000000000000" 8712000000000000000000000" 10368000000000000000000000" 12441600000000000000000000" 15168000000000000000000000" 18192000000000000000000000" 21600000000000000000000000" 25920000000000000000000000" 30240000000000000000000000" 36288000000000000000000000" 43200000000000000000000000" 51840000000000000000000000" 61440000000000000000000000" 72960000000000000000000000" 87120000000000000000000000" 103680000000000000000000000" 124416000000000000000000000" 151680000000000000000000000" 181920000000000000000000000" 216000000000000000000000000" 259200000000000000000000000" 302400000000000000000000000" 362880000000000000000000000" 432000000000000000000000000" 518400000000000000000000000" 614400000000000000000000000" 729600000000000000000000000" 871200000000000000000000000" 1036800000000000000000000000" 1244160000000000000000000000" 1516800000000000000000000000" 1819200000000000000000000000" 2160000000000000000000000000" 2592000000000000000000000000" 3024000000000000000000000000" 3628800000000000000000000000" 4320000000000000000000000000" 5184000000000000000000000000" 6144000000000000000000000000" 7296000000000000000000000000" 8712000000000000000000000000" 10368000000000000000000000000" 12441600000000000000000000000" 15168000000000000000000000000" 18192000000000000000000000000" 21600000000000000000000000000" 25920000000000000000000000000" 30240000000000000000000000000" 36288000000000000000000000000" 43200000000000000000000000000" 51840000000000000000000000000" 61440000000000000000000000000" 72960000000000000000000000000" 87120000000000000000000000000" 103680000000000000000000000000" 124416000000000000000000000000" 151680000000000000000000000000" 181920000000000000000000000000" 216000000000000000000000000000" 259200000000000000000000000000" 302400000000000000000000000000" 362880000000000000000000000000" 432000000000000000000000000000" 518400000000000000000000000000" 614400000000000000000000000000" 729600000000000000000000000000" 871200000000000000000000000000" 1036800000000000000000000000000" 1244160000000000000000000000000" 1516800000000000000000000000000" 1819200000000000000000000000000" 2160000000000000000000000000000" 2592000000000000000000000000000" 3024000000000000000000000000000" 3628800000000000000000000000000" 4320000000000000000000000000000" 5184000000000000000000000000000" 6144000000000000000000000000000" 7296000000000000000000000000000" 8712000000000000000000000000000" 10368000000000000000000000000000" 12441600000000000000000000000000" 15168000000000000000000000000000" 18192000000000000000000000000000" 21600000000000000000000000000000" 25920000000000000000000000000000" 30240000000000000000000000000000" 36288000000000000000000000000000" 43200000000000000000000000000000" 51840000000000000000000000000000" 61440000000000000000000000000000" 72960000000000000000000000000000" 87120000000000000000000000000000" 103680000000000000000000000000000" 124416000000000000000000000000000" 151680000000000000000000000000000" 181920000000000000000000000000000" 216000000000000000000000000000000" 259200000000000000000000000000000" 302400000000000000000000000000000" 362880000000000000000000000000000" 432000000000000000000000000000000" 518400000000000000000000000000000" 614400000000000000000000000000000" 729600000000000000000000000000000" 871200000000000000000000000000000" 1036800000000000000000000000000000" 1244160000000000000000000000000000" 1516800000000000000000000000000000" 1819200000000000000000000000000000" 2160000000000000000000000000000000" 2592000000000000000000000000000000" 3024000000000000000000000000000000" 3628800000000000000000000000000000" 4320000000000000000000000000000000" 5184000000000000000000000000000000" 6144000000000000000000000000000000" 7296000000000000000000000000000000" 8712000000000000000000000000000000" 10368000000000000000000000000000000" 12441600000000000000000000000000000" 15168000000000000000000000000000000" 18192000000000000000000000000000000" 21600000000000000000000000000000000" 25920000000000000000000000000000000" 30240000000000000000000000000000000" 36288000000000000000000000000000000" 43200000000000000000000000000000000" 51840000000000000000000000000000000" 61440000000000000000000000000000000" 72960000000000000000000000000000000" 87120000000000000000000000000000000" 103680000000000000000000000000000000" 124416000000000000000000000000000000" 151680000000000000000000000000000000" 181920000000000000000000000000000000" 216000000000000000000000000000000000" 259200000000000000000000000000000000" 302400000000000000000000000000000000" 362880000000000000000000000000000000" 432000000000000000000000000000000000" 518400000000000000000000000000000000" 614400000000000000000000000000000000" 729600000000000000000000000000000000" 871200000000000000000000000000000000" 1036800000000000000000000000000000000" 1244160000000000000000000000000000000" 1516800000000000000000000000000000000" 1819200000000000000000000000000000000" 2160000000000000000000000000000000000" 2592000000000000000000000000000000000" 3024000000000000000000000000000000000" 3628800000000000000000000000000000000" 4320000000000000000000000000000000000" 5184000000000000000000000000000000000" 6144000000000000000000000000000000000" 7296000000000000000000000000000000000" 8712000000000000000000000000000000000" 10368000000000000000000000000000000000" 12441600000000000000000000000000000000" 15168000000000000000000000000000000000" 18192000000000000000000000000000000000" 21600000000000000000000000000000000000" 25920000000000000000000000000000000000" 30240000000000000000000000000000000000" 36288000000000000000000000000000000000" 43200000000000000000000000000000000000" 51840000000000000000000000000000000000" 61440000000000000000000000000000000000" 72960000000000000000000000000000000000" 87120000000000000000000000000000000000" 103680000000000000000000000000000000000" 124416000000000000000000000000000000000" 151680000000000000000000000000000000000" 181920000000000000000000000000000000000" 216000000000000000000000000000000000000" 259200000000000000000000000000000000000" 302400000000000000000000000000000000000" 362880000000000000000000000000000000000" 432000000000000000000000000000000000000" 518400000000000000000000000000000000000" 614400000000000000000000000000000000000" 729600000000000000000000000000000000000" 871200000000000000000000000000000000000" 1036800000000000000000000000000000000000" 1244160000000000000000000000000000000000" 1516800000000000000000000000000000000000" 1819200000000000000000000000000000000000" 2160000000000000000000000000000000000000" 2592000000000000000000000000000000000000" 3024000000000000000000000000000000000000" 3628800000000000000000000000000000000000" 4320000000000000000000000000000000000000" 5184000000000000000000000000000000000000" 6144000000000000000000000000000000000000" 7296000000000000000000000000000000000000" 8712000000000000000000000000000000000000" 10368000000000000000000000000000000000000" 12441600000000000000000000000000000000000" 15168000000000000000000000000000000000000" 18192000000000000000000000000000000000000" 21600000000000000000000000000000000000000" 25920000000000000000000000000000000000000" 30240000000000000000000000000000000000000" 36288000000000000000000000000000000000000" 43200000000000000000000000000000000000000" 518			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries